



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3212-1

Job Sheet 200291



Part No: D3212-1

Job Qty: 4 pcs

DAS
21
9-89

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/14/19

Description:

Type: SOLD

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	10/14/19	10/14/19	0.17	0.40	Waterjet - Flow		ML 19/10/05
110	HAAS 4 Axis - B4B	4 pcs	10/14/19	10/14/19	1.00	0.96	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		ML 19/10/11
120	QC 2	4 pcs	10/14/19	10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		ML 19/10/11
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		ML 19/10/11
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		ML 19/10/11
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		ML 19/10/11
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		ML 19/10/11
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

Plex 9/10/19 8:08 AM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	4 pcs	10/14/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
140	Small Fab - 2 - B4B	4 pcs	10/14/19	0.00 0.94	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
150	QC 5	4 pcs	10/14/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30

On 19/10/12

OCT 16 2019

OCT 17 2019 40

9-88

160 Packaging 3-1 - Stock - B4B 4 pcs	10/14/19	0.00 0.00	QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
170 QC 21 - SA 4 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-35

OCT 18 2019

Part Op 100 - 1-Cut blanks.

Descriptions: 110 - (HAAS CNC Vertical Machine)

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Small Fab) 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4-

Wrap in plastic wrap after inspection

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2728-1	Dart Logo Label Small	4 pcs (1 ea)	100-Waterjet - Flow - 1	FM137519
MACRLICS.125	1/8" Polycast li Sheet	3.8980 sf (.9745 ea)	140-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	D2728-1	4	3,000	0
140-Small Fab - 2 - B4B	MACRLICS.125	4	1,571	0
Part Specifications				
Specifications could not be found.				

Plex 9/10/19 8:08 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	200291
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	/		Height G	31005
6.367	+/-0.005	6.366	/		"	
0.625	+/-0.005	0.625	/		vern	
Ø0.156	+0.005/-0.001	0.157	/		"	
R0.25	+/-0.030	.25	/		RG	
8.150	+/-0.005	8.148	/		Height G	31006
3.750	+/-0.005	3.750	/		"	
0.313	+/-0.010	0.313	/		vern	mmL-05
15.14	+/-0.030	15.147	/		Height G	31006
12.520	+/-0.005	12.520	/		"	
6.260	+/-0.005	6.258	/		vern	mmL-05
1.312	+/-0.005	1.310	/		"	
0.313	+/-0.010	.313	/		"	
3.750	+/-0.005	3.750	/		Height G	31006
8.150	+/-0.005	8.150	/		"	
8.462	+/-0.005	8.462	/		"	
9.09	+/-0.030	9.095	/		Height G	31006

Measured by: mmL	Audited by: mmL	Preliminary Approval:
Date: 19/10/11	Date: 19/10/12	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			

Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread									
		Other/Details:									